

Work Order ID 56090

February 10, 2010 12:12:08 PM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 2/10/10 Start Qty: 5.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *R*

Date: *10-2-10*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

0.00

100



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

5/10/03/04

HJ for CL 10/03/04

110



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R ☐ Aluminum Rod *1110130*

3-Grind End Plate flush *1111311*

1/210.02.22

5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

x5

0

BE 10/02/25

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/02/24

x5
44

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10.02.24

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/02/20

X5

0

180

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272. *th*

2-Leave one rivet out until welding is complete. *th*

3-Bevel Aft end for welding *th*

4-Inspect for foreign object as per QSI 024 *th*

5-Weld Aft End Plate as per QSI 004 & Dwg D3272 *th*

A/R ☐ Aluminum Rod *M111311*

6-Grind End Plate flush *th*

7-Install last rivet as per Dwg. *th*

10-02-25

5

0

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(S)

100226

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5.06/26

(25
41)

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 10/08/03

(5h/4)

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1113170 Memo START TIME: 11:00 AM OVEN TEMPERATURE: 320°F FINISH TIME: 11:30 AM	0.00 0.00	=> 11	10/03/03		(X5H) 9			
230 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch Memo	0.00 0.00	16K	10-08-8		(52H)			
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	S	10/03/04		(X5 4H)			

W/O:		WORK ORDER CHANGES					
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Required Date: 2/26/10 Req'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-3-4 SL (SK)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S idig/04

(X5 4H)

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311
Location: MEU B

10/4/3/5 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11
ME

10-3-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 56090

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3065-041		Manufactured	No				Each	60.0000	5.0000			
Step Leg Assembly Hi												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	60	
53795	30	
55450	30	

D3066-1		Manufactured	No				Each	42.0000	10.0000			
Spacer												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	42	
51545	11	
53783	31	

D3219-1		Manufactured	No				Each	62.0000	10.0000			
Plate												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	62	
53789	62	

10.02.25

10.02.25

10.02.22

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 56090



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev: A 04.03.22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3272-1 JLM

IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by: EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3067-1		Manufactured	No			110	Each	53.0000	5.0000			



End Plate



10.02.22

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

53

53784

53

D3272-1

Manufactured

No

110

Each

0.0000

5.0000



Step

MS21042L5

Purchased

No

110

Each

459.0000

10.0000



Nut



5

10.02.22 356091

10-3-2

SD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

458

110382

10

111636

1

112314

20

113523

227

113537

200

10

Main Warehouse

ST139

1

112314

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Required Date: 2/26/10

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IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS20600-AD4W4		Purchased	No			180	Each	1,203.000	80.0000			
Rivets												

10.05.25

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1203
110731	215
111359	46
111477	74
112314	344
112385	24
113368	500

80

AN3-35A

Purchased

No

260

Each

201.0000

10.0000



Bolt

10-3-24

SP (5x)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	201
106993	12
110467	1
112314	188

10

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Shop Packet Print

Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4-13A		Purchased	No			260	Each	269.0000	40.0000			



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

269

~~113359~~

69

~~113749~~

200

~~17406~~

0

~~51764~~

0

AN5-36A

Purchased

No

260

Each

115.0000

10.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

115

109545

11

110467

7

110731

4

112243

20

112314

23

~~112385~~

50

Purchased

No

260

Each

0.0000

20.0000



Washer

1113288 10-3-4



QSI OIT SD

1113288

AN960JD10



Washer

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Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD416		Purchased	No			260	Each	0.0000	80.0000			
										M113706	10-3-4	SL
Washer												
AN960JD516		Purchased	No			260	Each	0.0000	20.0000			
										M113524	10-3-4	SL
Washer												
D2230-3		Manufactured	No			260	Each	13.0000	20.0000			
										20 B55340	10-3-4	SL
Lug												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7	
50306	5	
51568	2	
Main Warehouse		
ST176	5	
53881	5	
Main Warehouse		
ST476	1	
53781	1	

(52)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2618		Manufactured	No			260	Each	61.0000	10.0000			
										10-3-4	SL	
Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST39

61

50989

61

260

f

264.9521

3.0000

10

10-3-4

SL

D2856-400



Abraison Strip

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

264.9520842

50593

141.312084

52563

123.64

260

Each

53.0000

5.0000

D3067-1



End Plate

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

53784

53

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 2/10/10

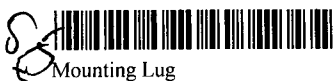
Required Date: 2/26/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
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IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3235-1		Manufactured	No			260	Each	47.0000	10.0000			



Mounting Lug



10-3-4

SL

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST

47

45398

4

54756

43

260

Each

63.0000

5.0000



10

10-3-4 SP

SL

D3278-041

Manufactured No



Support Assembly

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST

23

53227

23

Main Warehouse

ST471

40

55318

40

5

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 10, 2010 12:12:13 PM

Work Order ID: 56090



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L3		Purchased	No			260	Each	2,681.000	10.0000			
										10-3-4	5d	
Nut												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2675	
110844	35	
111274	27	
111668	52	
112314	289	
112385	498	10
113523	74	
113537	700	
113644	1000	
Main Warehouse		
ST139	6	
111668	6	

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MS21042L4		Purchased	No			260	Each	2,535.000	40.0000			
										10-3-4	54	52
Nut												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2535	
102552	6	
104248	6	
110507	184	
111827	1339	
113422	1000	
15924	0	

32

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DESIGN <i>90</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△
B

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *36090*
BS 10-2-10

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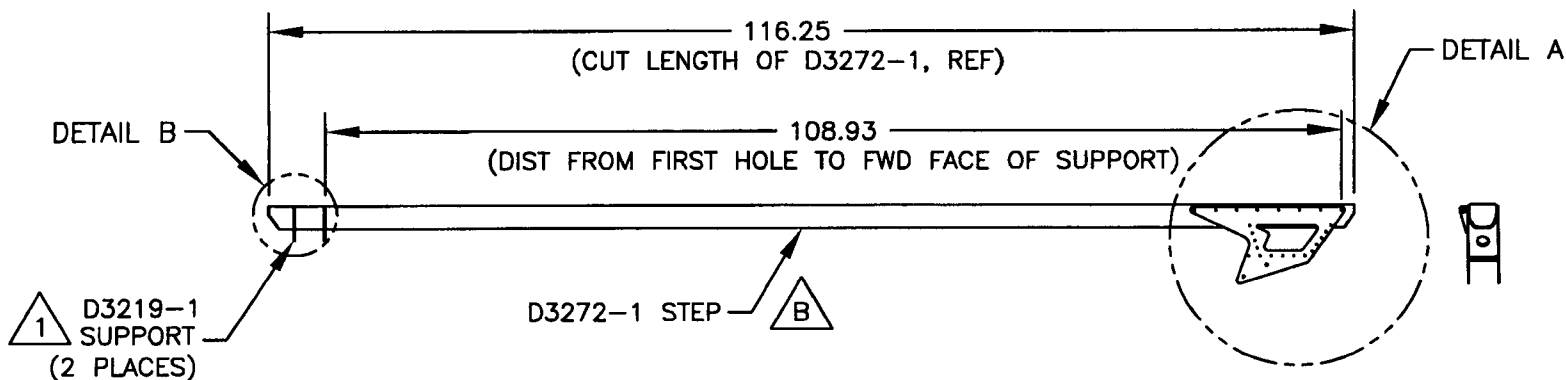
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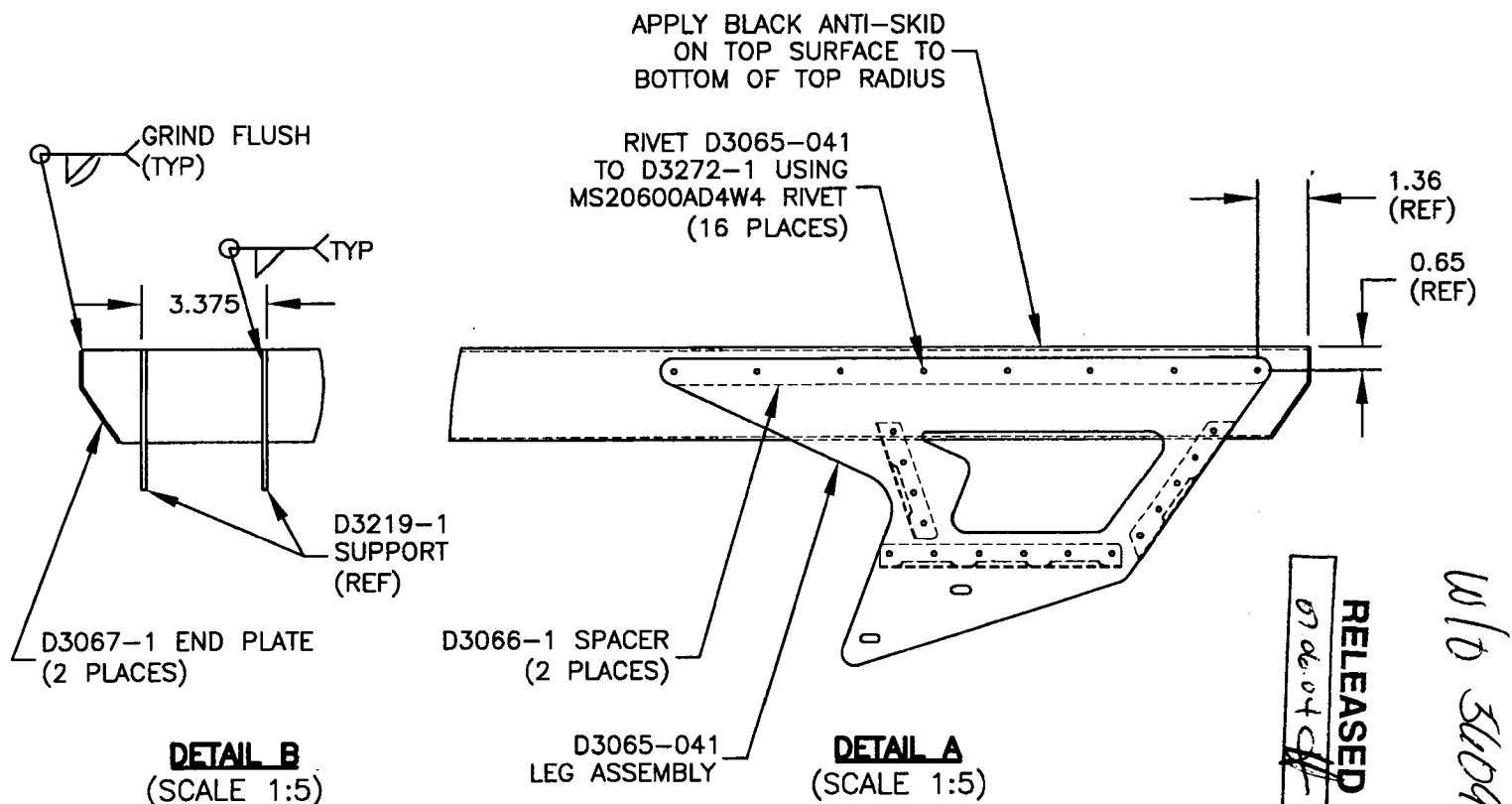
NOTE: Date & initial all entries



DESIGN	90	DRAWN BY	JS	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JS	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	D3272	REV. B
			STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

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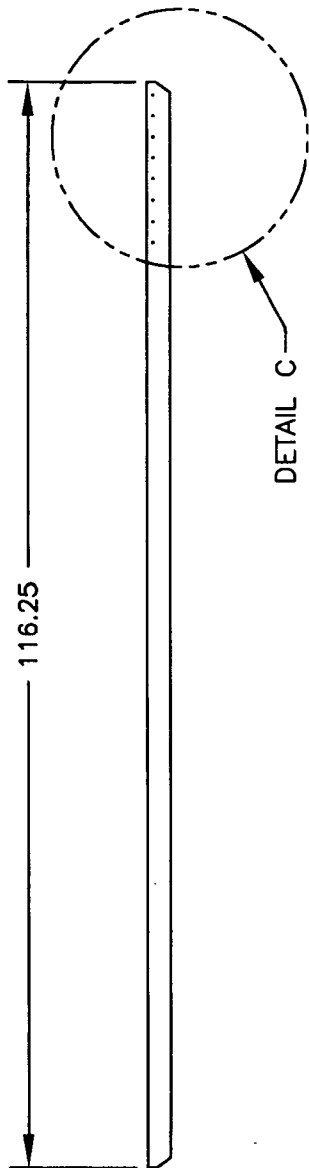


DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

W/O 56090

RELEASED

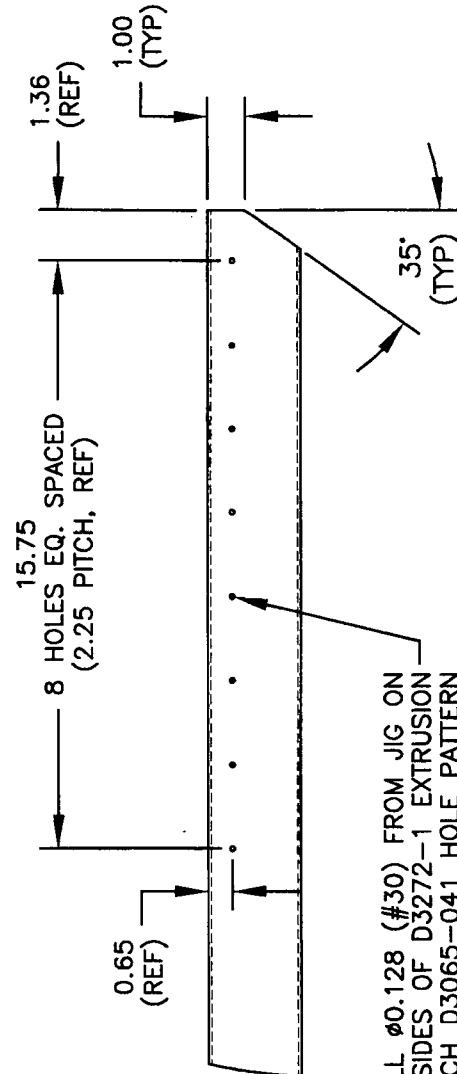
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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